

Date: Monday, 23/02/2009 10:09:45 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : RIB ASSY (BASKET LID, RH)
<b>Job Number</b> : 45947	
<b>Estimate Number</b> : 13664	
<b>P.O. Number</b> :	<b>Part Number</b> : D3838042
<b>This Issue</b> : 23/02/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3838 REV A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 44773	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 27/02/2009 <b>Qty:</b> 2 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUD 09.02.23</u>	
<b>Comment</b> : Est Rev:A 08-12-01 new issue DD verified by:EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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✓ 1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
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**Comment:** Qty.: 1.0833 f(s)/Unit Total : 2.1666 f(s)  
 304 SQ Tube .75x.75x.065W  
 batch: M110011

SAD 09-02-24

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1  
 1- cut D3838-2 and D3838-3 rib as per dwg D3838  
 2- c/sink hole as per dwg  
 3- remove identification markings  
 4- deburr

SAD 09-02-24 (2)

3.0	QC5	INSPECT WORK TO CURRENT STEP
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**Comment:** INSPECT WORK TO CURRENT STEP

SAD 09/02/24 (2)

4.0	D37591	Bushing
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
 Bushing  
 batch: B45794 → 2x

SAD 09/02/25

5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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**Comment:** LARGE FABRICATION RESOURCE 1  
 1- weld D3838-2 to D3838-3 and drill hole (3/16") using DT9437 jig and open to finish size as per dwg D3838  
 A/R ER316 S.S. Rod Batch: M108775  
 2- grind weld flush where indicated on dwg D3838

SAD 09/02/25 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Monday, 23/02/2009 10:09:45 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RIB ASSY (BASKET LID, RH)

Job Number: 45947

Part Number: D3838042

Job Number:



Seq. #:

Machine Or Operation:

Description :

3- weld D3759-1 bushing as per dwg D3838 *ds*  
4- grind bushing weld flush as per dwg dwg D3838 *ds*  
5- deburr hole if necessary *ds*

*dy 09/02/25 (2)*

6.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*PD 09-02-25 (2)*

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*PD 09-02-25 (1)*

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: *Basket*

*PD 09-02-25 (2)*

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*09/02/26 ds*

Job Completion



*U 09.02.25*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

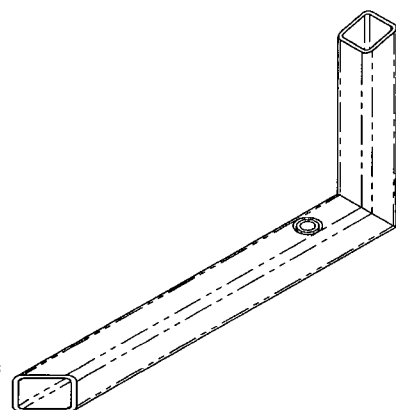
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

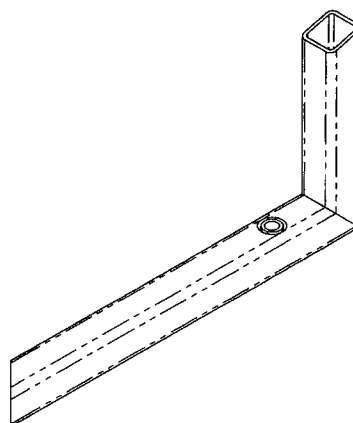
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3838-041	RIB ASSY (BASKET LID, LH)
2		X	D3838-042	RIB ASSY (BASKET LID, RH)
3	1	1	D3759-1	BUSHING
4	1		D3838-1	RIB
5		1	D3838-2	RIB
6	1	1	D3838-3	RIB



**D3838-041 RIB ASSY (BASKET LID, LH)**





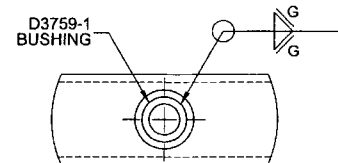
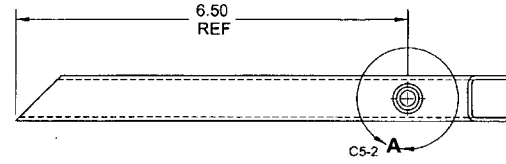
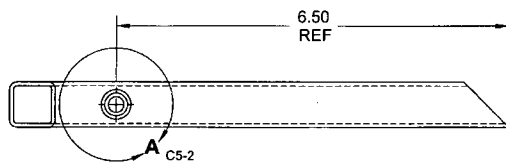
**D3838-042 RIB ASSY (BASKET LID, RH)**

**RELEASED**  
08/11/12

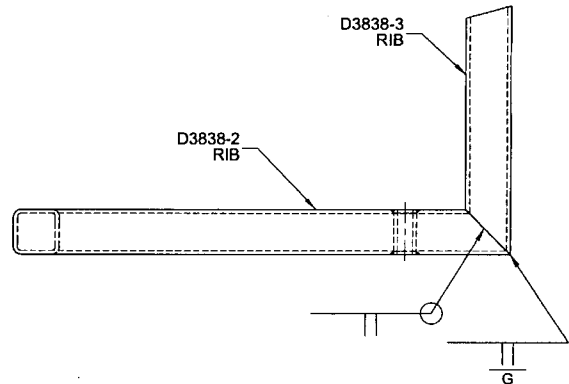
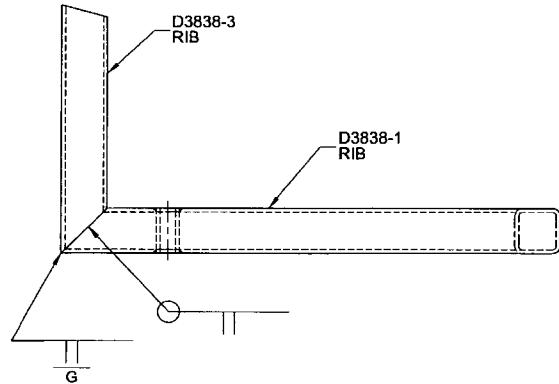
SHOP COPY  
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WITHOUT NOTICE  
WORK ORDER  
NO. 15947

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: NONE
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.54 lbs

A	NEW ISSUE		MB	08.10.08
REV.		DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	REV. A SHEET 1 OF 3 SCALE NTS	
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.		DRAWING NO. D3838	REV. A	
DATE	08.10.08	TITLE RIB ASSY (BASKET LID)	SHEET 1 OF 3	
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**DETAIL A**  
D2-2  
D7-2 SCALE 2X



**D3838-041 RIB ASSY (BASKET LID, LH)**

**D3838-042 RIB ASSY (BASKET LID, LH)**

**RELEASED**  
08/11/18

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WORK ORDER  
NO. 43947

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3838</b>	REV. A
MFG. APPR.		SHEET 2 OF 3	
APPROVED		TITLE <b>RIB ASSY (BASKET LID)</b>	SCALE NTS
DE APPR.		COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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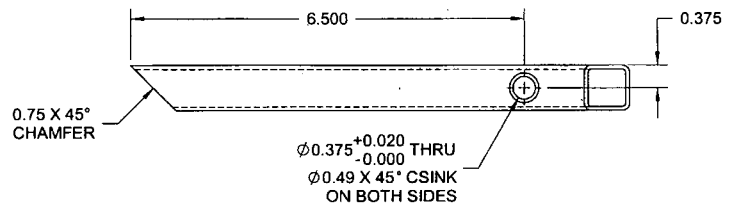
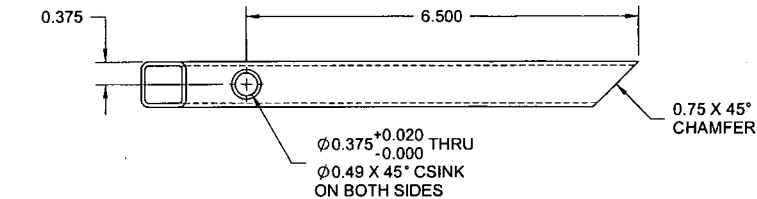
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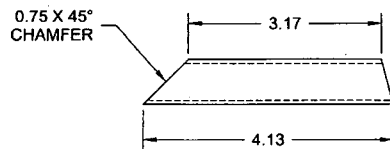
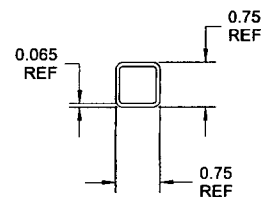
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**D3838-1 RIB****D3838-2 RIB**

C

C

**D3838-3 RIB****TYPICAL SECTION  
VIEW**

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WITHOUT NOTICE  
WORK ORDER

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL  
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1/2 = 0.35 lbs EACH; D3836-3 = 0.19 lbs

**RELEASED**  
26/11/18 N.H.

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3838</b>	REV. A
MFG. APPR.			SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>RIB ASSY (BASKET LID)</b>	NTS
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